

Work Order ID 76239


76239

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Monday, November 07, 2011 2:46:29 PM

Item ID: D3504-5 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Crossbolt Spacer
 Start Date: 11/7/2011 Start Qty: 16.00 ***16*** Cust Item ID:
 Required Date: 11/16/2011 Req'd Qty: 16.00 ***16*** Customer:

Reference:

Approvals: Process Plan:  Date: 11/11/07 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3504	Rev C

100	Hardinge CNC LATHE SMALL	0.00		11/12/01		16			
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100

Hardinge

Hardinge CNC Lathe Small

Memo

1-TURN AS PER FOLIO FA712 & DWG D3504 ,FOLIO
 REV: _____ DWG REV: _____ 2-DEBURR AS REQUIRED

Manual Lathe

110	QC2- Inspect parts off machine FAI/FAIB	0.00		11/12/02		16			
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110

QC

Quality Control

Memo


120	QC8- Inspect parts - second check	0.00							
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120

QC

Quality Control

Memo

 11 12 02 (16)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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mf
11-12-00

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Picklist Print

Monday, November 07, 2011 2:46:34 PM

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Work Order ID: 76239

76239

Parent Item: D3504-5

D3504-5

Parent Item Name: Crossbolt Spacer

Start Date: 11/7/2011

Required Date: 11/16/2011

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP Rev:A Rev C dwg 07-12-06 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.750		Purchased			No	100	f	37.8280	0.3077	5.182316			

M6061T6R0 750

6061-T6 Round Bar .750"

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT013	37.828	
112442	0.796	
117481	1.969	
118106	1.338	
119231	33.725	

5.5 *[Signature]* 11/12/02

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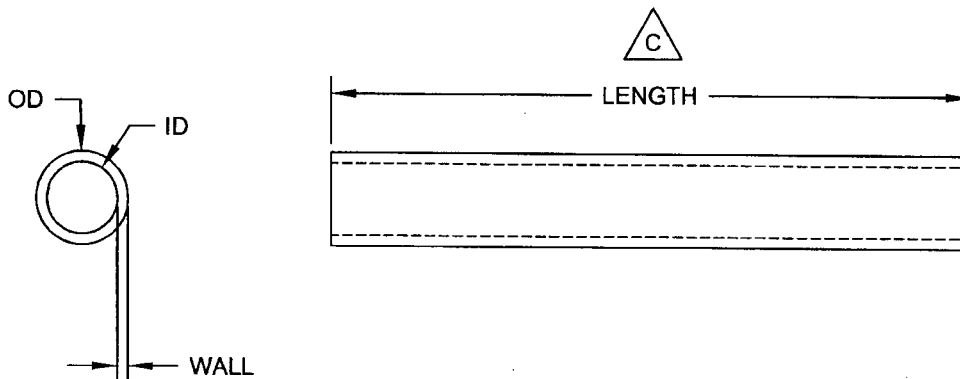
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D3504-1/-3/-5 CROSS BOLT SPACER PARTS LIST

PART NUMBER	OD	WALL	LENGTH +0.030 -0.000	ID	MATERIAL SPEC	NOTE
D3504-1	0.500	0.049	3.475	0.402 (REF)	M6061T6T0.500W.049	SEE NOTE 1a)
D3504-3	0.375	0.049	3.475	0.277 (REF)	M6061T6T0.375W.049	SEE NOTE 1a)
D3504-5	0.750	0.080 (REF)	3.400	0.590	M6061T6R0.750	SEE NOTE 1b)

D3504-1/-3/-5 CROSS BOLT SPACER:

- 1) MATERIAL: a) 6061-T6 OR 6061-T62 TUBING
PER WW-T-700/6 OR AMS 4080 OR AMS 4082
OR QQ-A-200/8 OR QQ-A-225/8
(REF. DART SPEC. M6061T6TD.DDDW.TTT)
- b) 6061-T6 (OR 6061-T651/T6510/T6511/T62) ROUND BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6R0.750)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

RELEASED
07.11.16

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 74239

C	ADD -5	DC	07.09.19
B	3.475 WAS 3.400	PH	06.11.01
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>DC</i>		
CHECKED	<i>PH</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>PH</i>	D3504	SHEET 1 OF 1
APPROVED	<i>PH</i>	TITLE	SCALE
DE APPR.	<i>PH</i>	CROSS BOLT SPACER	NTS
DATE	07.09.19	COPYRIGHT © 2006 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

PH-11-02

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